

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BLADE
Job Number	: 24750		
Estimate Number	: 10327		
P.O. Number	: N/A	Part Number	: D2741
This Issue	: 11/11/2005 S.O. No. : N/A	Drawing Number	: D2741 REV B2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B2
Previous Run	: N/A	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 11/30/2005
Checked & Approved By	: SEE ABOVE DATE & USER	Qty:	20 Um: Each
Comment	: Est D 00.11.15 Removed P/O turning - in house process E C		

Job Number:

Page 1

Date: Friday, 11/11/2005 2:41:03 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE

Job Number: 24750

Part Number: D2741

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

M8 06/02/06

20

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Bend per Dwg D2741

FF 06.02.24

SB 06/02/13

20

20

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-02-14

20

8.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 00000578

Harden material as per Dwg D2741

Min. Ultimate Tensile Strength = 152 ksi (30-40 HRC)

Min. Yield Tensile Strength = 141 ksi

Test report or Certification required

06/02/15

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

Ensure Test report or Certification attached

C 06/02/28

20

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-03-01

20

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

a.m 06-03-03

20

Date: Friday, 11/11/2005 2:41:03 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE

Job Number: 24750

Part Number: D2741

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Pc 6/3/6 20

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

57150

Pc 6/3/6 (20)

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

28
06/03/07

Job Completion

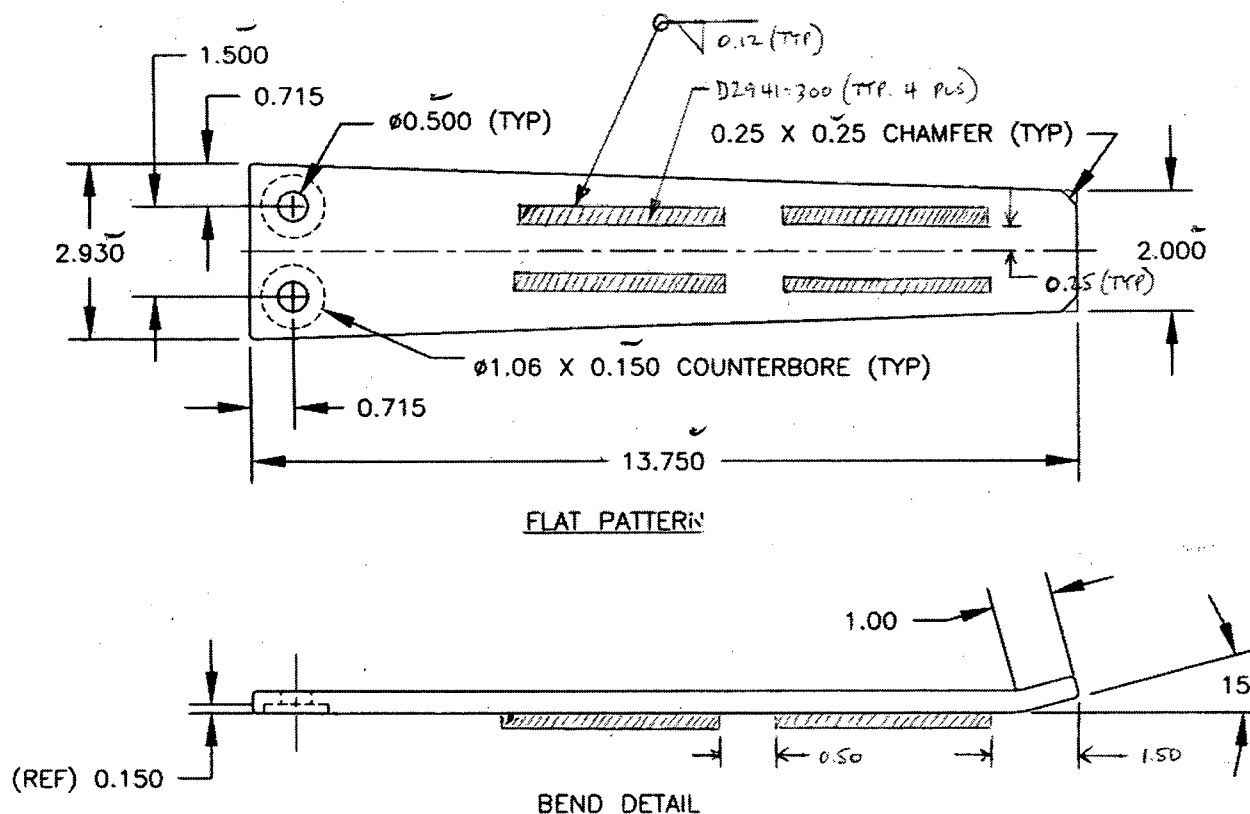


W 06/03/07

DART



RELEASED
98-11-03 DS



#01-02-25
BZ 01-02-26

MATERIAL: AISI 4130 STEEL 0.375 THICK
 MIN. ULTIMATE TENSILE STRENGTH = 152 ksi (34-40 HRC)
 MIN. YIELD TENSILE STRENGTH = 141 ksi
FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 BREAK SHARP EDGES 0.030 TO 0.060

01-01-31 41-041, WELD 2941-300 (4) AS SHOWN ABOVE. REMOVE POWDER
 SURFACE OF D2941-300
 01-02-25 01-043, WELD 7560 HARDCOAT ROD INSTEAD OF D2941-300

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	FAIRCHILD INTERNATIONAL AIRPORT, WA
DATE	TITLE	REV. B
98.09.01	BLADE	SHEET 1 OF 1
A	NEW ISSUE	SCALE
B	CHANGE C/SINK TO C'BORE	1:3
B1	ADD 2941-041/-043 OPTIONS	
B2	ADD ROCKWELL HARDNESS	

□□□□□□□□

Job Costing Report

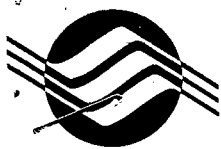
Dart Aerospace Ltd.
Hawkesbury

Nov 10, 2005
07:04 am

Work Order No	: 0024750	Department Code:	
Project Name	: D2741	Burden Flags	: NNNNNNNN
Project For	: WK547	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2741	Invoice Number	:
Description	: Blade	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 20	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 11-09-05		
Est Finish Date	: 11-24-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00



VAC AERO

INTERNATIONAL INC.

PACKING SLIP

OAK 72793-1



HEAD OFFICE

1371 SPEERS ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
TEL: (905) 827-4171 FAX: (905) 827-7489



QUEBEC DIVISION

7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

GST No.: R105468102

02/24/2006

MM / DD / YYYY

PAGE: 1

BILL TO: 1DAR01
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
02/24/2006		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
104525		COD

LN	PART NO	DESCRIPTION	UOM	QTY ORDERED	QTY SHIPPED	B/O QTY
01	D2741	BLADE - C 206102128 Process Specifications: Procedure: 4161 HARDENED PER DWG. D2741 TO 152 KSI MINIMUM HRC 34-40 MATERIAL: 4130 B24750	EA	20	20	0
02	MC	MINIMUM CHARGE		1	1	0

No claims for shortage in weight or count will be entertained, unless presented within 5 working days after receipt of materials by customer.



VACUUM BRAZING · HEAT TREATING · SPECIAL PROCESSING · FURNACE EQUIPMENT
· THERMAL SPRAYING · PLASMA AND OTHER COATINGS



HEAT
TREATING



RELEASE NOTE

GST No. : R105468102

OAK 72793-1

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SHIP TO: DART AEROSPACE LTD.
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HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
02/24/2006		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
104525		COD

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D2741	BLADE	EA	20	20	
<p>Process Specifications: Procedure: 4161 HARDENED PER DWG. D2741 TO 152 KSI MINIMUM HRC 34-40 MATERIAL: 4130</p> <p>B24750 ✓</p> <p>90570</p> <p>100% HARDNESS TESTED 20 p.c. 35/36 HRC</p> <p>VA.I.Q. TH. 25 Q.C.</p> <p>6.03-01</p>					

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

Sandra Freeman
Authorized Q.C. Inspector



VACUUM BRAZING · HEAT TREATING · SPECIAL PROCESSING · FURNACE EQUIPMENT

HEAT
TREATING